

Date: Thursday, 3/13/2008 10:23:02 AM
 Kim Johnston

Process Sheet

13

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT X-TUBE EXT HEIGHT(-013)
 Job Number : 37951
 Estimate Number : 10563
 P.O. Number :
 This Issue : 3/13/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D205596107
 First Issue : 1 / Type : LANDING GEAR Drawing Number : D205596107
 Previous Run : 37950 Drawing Revision : B
 Material :
 Due Date : 3/27/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 08 03 13
 Comment : Est Rev:D 05.03.21 Added bending procedure KJ/JLM
 Est Rev:E 08-01-10 ECN 1075 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-107CHG002

08/03/19 75

2.0 D2890 Aft Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:

Qty Part number Description Batch
 1 D2890 Aft Crosstube

B38043 DP 8-4-3

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

DP 8-4-3

4.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

5 08/04/13 (1)

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-107 FT 08-04-03

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

AJM 8-4-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:23:02 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 37951

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/09 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

ANM 8-4-4

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 08/04/09 (10)

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

AT 08-04-08

10.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

MA 08 04 09: (1)

11.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION

batch 37970

MA 08 04 09

12.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch 106864

MA 08 04 09

13.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

2 D2940-1

Description

Support

Batch

35582

MA 08 04 09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:23:02 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 37951

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



see att.



Comment: LANDING GEAR RESOURCE 1

1- Apply magnobond 6398 as per dwg D205-596-107

Magnobond 6398 Batch: _____

2-Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. as per dwg

MF 080409

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/10 @

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-107

Location: 0

PPP Rev: 0

08/04/11 (1)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 12:58:47 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT X-TUBE EXT HEIGHT(-013)
Job Number	: 37951		
Estimate Number	: 10563		
P.O. Number	:	Part Number	: D205596107
This Issue	: 04/04/2008 S.O. No. :	Drawing Number	: D205596107
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 13/03/2008 Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 37950	Material	:
Written By	:	Due Date	: 27/03/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:D 05.03.21 Added bending procedure KJ/JLM		
	: Est Rev:E 08-01-10 ECN 1075 DD		

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

140

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Apply magnobond 6398 as per dwg D205-596-107

Magnobond 6398 Batch: 106695 Time: 1.00pm > ml 08 04 09 ①

exp: 04/2009

2-Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. as per dwg mm 08 04 10 ①

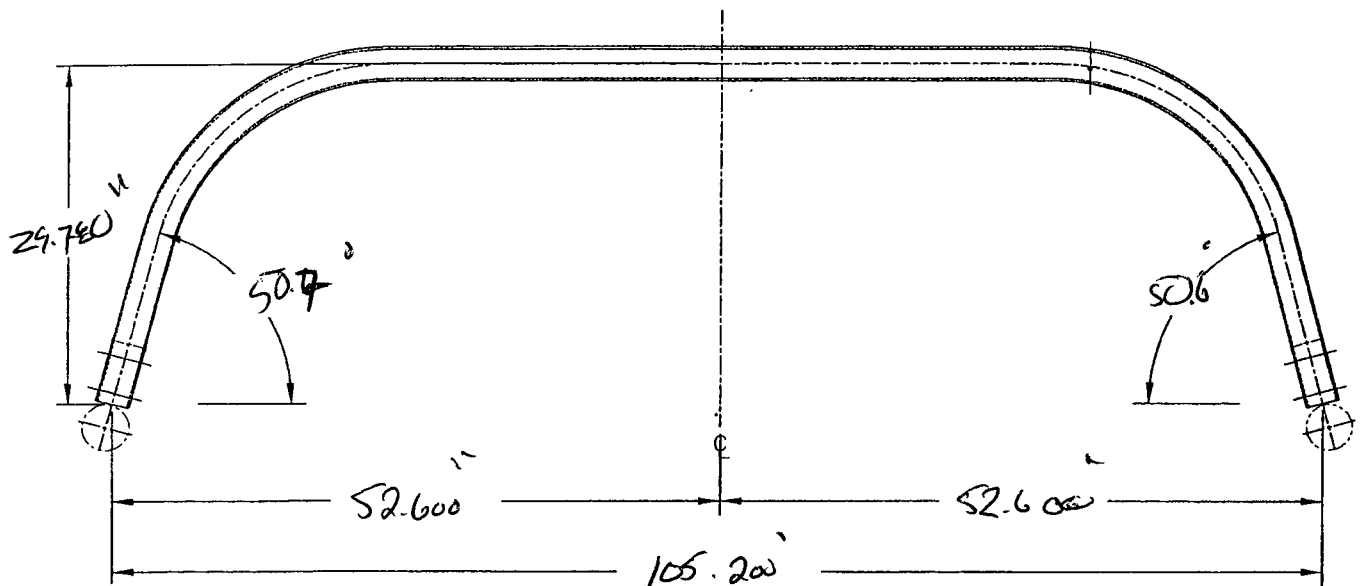
Job Completion



DART AEROSPACE LTD		Work Order:	37951
Description: Crosstube High-High Aft		Part Number:	D205-596-107
Inspection Dwg: D205-596-107 Rev: <i>AB</i>		Page 1 of 1	

9/08/03.13

Required Dimension	Min	Max
Height	29.7	29.9
1/2 Span	52.4	52.6
Angle	49	52
Total Span	104.8	105.2



Comments

QC15 Inspection	
Date	08/04/03

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

[Signature]

PARTS LIST:

Qty	Part Number	Description
X	D205-596-107	CROSSTUBE ASSEMBLY, HI-HI AFT
1	D6008-180	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 127.28 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH
VIBRATING STYLUS
- 7) WEIGHT: 50 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
**NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER
MS21920-XX CLAMPS TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF
1.5 THREADS IN SAFETY ON THE NUTS.**
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

W/ HOLT NOTICE

WORK ORDER

NO 37951

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION	MB	07.12.03
A	NEW ISSUE	DS	02.11.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D205-596-107	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASSEMBLY, HI-HI AFT	NTS
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